



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3884-2**Job Sheet 187258****Part No:** D3884-2**Job Qty:** 10 ea**Part Name:** Saddle, Inside RH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/29/18**Job Tracking No:****Due Date:** 1/31/19**Created By:** Jesse White**Type:** Stock**Description:**

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/31/19	0.00	0.00	Start Up Machining-2		SBZ 19/01/10
100	CNC Vertical Machining	10 pcs		1/31/19	0.31	17.54	HAAS1-5		SBZ 19/01/10
110	QC	10 pcs		1/31/19	0.00	0.00	QC2 Machining-2		SBZ 19/01/11
120	QC	10 pcs		1/31/19	0.00	0.00	QC8 Machining-2		DR 19/01/14
130	HandFinish	10 pcs		1/31/19	0.00	0.94	HandFinish1		DR 19/01/15
140	Powdercoat	10 pcs		1/31/19	0.00	0.52	Powdercoat1		DEB 19/01/16
150	QC	10 pcs		1/31/19	0.00	0.00	QC3		2019 01/21
160	Packaging	10 pcs		1/31/19	0.00	0.00	Packaging3-2		2019 01/21
170	QC21-SA	10 Ea		1/31/19	0.00	0.00	QC21		2019 01/21

Part Op 100 - Program Batch No. 5143415 - Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets 2-
Descriptions: Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA819
and inspect per Dimension Sheets

140 - *MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)*****

M138997 START: 1:25 TEMP: 320° FINISH: 1:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-017	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	S102530 → x9 S134206 → x1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-017	10	19	0

Part Specifications

Specifications could not be found.

Plex 11/29/18 11:08 AM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____ Date : _____ Description Work Order Deviation	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Tab	DEPARTMENT/PROCESS (Non-AW) ☐ Eng. Coord. ☐ Packaging ☐ DART AEROSPACE Part: D3884-2 Job No: 187258 Serial No/Batch: S143415 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 01/10/19 Container No: S143415 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com
		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐ MRB (QSI042)
		Completed By Lead hand / Supervisor QC / QA Coordinator

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	FAULT CATEGORY Other/Details: _____
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DART AEROSPACE LTD		Work Order: 187258
Description: Saddle, Inboard, RH		Part Number: D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.647	0.647	0.647	0.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.257	0.257	0.257	0.257		
F	0.605	0.625		0.613	0.614	0.615	0.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		0.152	0.153	0.150	0.151		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		0.125	0.125	0.125	0.125		
M	0.240	0.260		0.250	0.250	0.251	0.251		
N	0.110	0.140		0.138	0.137	0.137	0.138		
O	0.240	0.260		0.250	0.249	0.250	0.250		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.151	0.152	0.151	0.152		
S	0.720	0.780		0.766	0.768	0.777	0.765		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.503	0.500	0.501	0.500		
Y	0.020	0.040		0.030	0.027	0.027	0.027		
Z	0.313	0.318		0.313	0.313	0.313	0.313		
AA	0.760	0.765		0.760	0.760	0.760	0.760		
AB	0.215	0.220		0.219	0.219	0.219	0.219		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.75		
AE	0.990	1.010		0.999	0.999	0.999	0.999		
AF									
Accept/Reject									

Measured by: DAS
Date: 57 19/01/10
9-89

Audited by: <i>m</i>
Date: 19/01/14

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 187 258
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Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5 ±	6 2	7 3	8 4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		1.647	1.647	1.647	1.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		1.257	1.257	1.257	1.257		
F	0.605	0.625		1.615	1.615	1.615	1.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.500	2.500	2.500	2.500		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		1.152	1.152	1.152	1.152		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		1.125	1.125	1.125	1.125		
M	0.240	0.260		1.250	1.250	1.250	1.250		
N	0.110	0.140		1.133	1.135	1.136	1.136		
O	0.240	0.260		1.250	1.250	1.250	1.250		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		1.188	1.188	1.188	1.188		
R	0.140	0.165		1.152	1.152	1.152	1.152		
S	0.720	0.780		1.760	1.762	1.760	1.760		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		1.501	1.501	1.500	1.500		
Y	0.020	0.040		1.030	1.030	1.030	1.028		
Z	0.313	0.318		1.316	1.316	1.316	1.316		
AA	0.760	0.765		1.760	1.760	1.760	1.760		
AB	0.215	0.220		1.219	1.219	1.219	1.219		
AC	0.316	0.321		1.316	1.316	1.316	1.316		
AD	1.745	1.755		1.750	1.750	*1.750	1.750		
AE	0.990	1.010		1.999	1.998	1.998	1.999		
AF						*1.750			
Accept/Reject									

Measured by:	DAS
Date:	57 19/01/14

Audited by:	
Date:	19/01/14

Rev	Date	Change	Revised by	Approved
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E	0.257	0.262		0.257	0.257				
F	0.605	0.625		0.615	0.614				
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J	0.140	0.175		0.152	0.152				
K	1.265	1.285		1.265	1.265				
L	0.115	0.135		0.125	0.125				
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N	0.110	0.140		0.138	0.138				
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W	2.495	2.505		2.500	2.500				
X	0.490	0.510		0.500	0.500				
Y	0.020	0.040		0.025	0.028				
Z	0.313	0.318		0.313	0.313				
AA	0.760	0.765		0.760	0.760				
AB	0.215	0.220		0.219	0.219				
AC	0.316	0.321		0.316	0.316				
AD	1.745	1.755		1.750	1.750				
AE	0.990	1.010		0.999	0.999				
AF									
Accept/Reject									

Measured by: DAS	Audited by: <i>[Signature]</i>
Date: 57 19/01/11	Date: 19/01/14

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ <i>[Signature]</i>	<i>[Signature]</i>